

18

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>20694</b>
<b>Description:</b> Spacepod Hardware Kit	<b>Part Number:</b>	<b>K10018</b>
<b>Dwg:</b> D2174 Rev. C; D2174-041 Rev. C; D2175 Rev. C 03.04.30	<b>Qty:</b>	<b>4 Kits</b>
		Page 1 of 2

Step	Location	Procedure	By	Date	Qty								
1	DC	Issue Traveler <b>Note: K10018 Kit to be made in multiples of 7.</b> <b>(1) K10018 requires (2) D2174-041.</b> <b>(1) D2174-041 consists of (1) D2174-1 Web &amp; (2) D2175 Angle</b>		04.04.13	4								
2	MV	Cut blanks: (12.000" x 3.850") Material: 2024-T3 (QQ-A-250/5) 0.063" thick sheet (M2024T3S.063) <b>Use stack of 7</b> <b>Identify for D2174-1</b> Batch: _____											
3	MV	<b>Cut (2) blanks per (1) K10018 Kit</b> Cut blanks: (12.200" x 2.960") <b>grain along 2.960</b> Material: 2024-T3 (QQ-A-250/5) 0.063" thick sheet (M2024T3S.063) <b>Use stack of 7</b> <b>Identify for D2175</b> Batch: _____											
4	MV	Machine D2174-1 as per Folio FA097 and Dwg D2174-1 <b>Identify as D2174-1</b>											
5	QC2	Inspect parts as they come off the CNC machine											
6	MV	Deburr for measurement											
7	QC8	Second check											
8	MV	Machine D2175 as per Folio FA083 and Dwg D2175 <b>Identify as D2175</b>											
9	QC2	Inspect parts as they come off the CNC machine											
10	MV	Deburr for measurement											
11	QC8	Second check											
12	GA	Deburr D2174-1 and D2175 stacks											
13	GB	Form D2175 Angle as per Dwg D2175											
14	QC5	Inspect work to Step 13											
15	FP	Chemical Conversion Coat per QSI 005 4.1 and Dwg D2174-1 and D2175											
16	QC3	Inspect work to Step 15											
17	GA	Assemble D2174-1 and D2175 as per Dwg D2174-041 <b>Pick:</b> <table><tr><td><u>Qty</u></td><td><u>Part Number</u></td><td><u>Description</u></td><td><u>Batch</u></td></tr><tr><td>23</td><td>MS20470AD4-6</td><td>Rivet</td><td></td></tr></table> <b>Identify as D2174-041</b>	<u>Qty</u>	<u>Part Number</u>	<u>Description</u>	<u>Batch</u>	23	MS20470AD4-6	Rivet				
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23	MS20470AD4-6	Rivet											
18	QC5	Inspect work to Step 17											
19	FP	Powder Coat White (Ref: 4.3.5.1) as per QSI 005 4.3											
20	QC3	Inspect Powder Coat. Go to KP cell for packing.											

Work Order:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

NCR		WORK ORDER NON-CONFORMANCE						
DATE	STEP	Description of NC section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial					

PAR#: \_\_\_\_\_ Fault Category: \_\_\_\_\_ DQA: \_\_\_\_\_ Date: \_\_\_\_\_

**NOTE:** Date & initial all entries  
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QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	20694
<b>Description:</b> Spacepod Hardware Kit	<b>Part Number:</b>	K10018
<b>Dwg:</b> D2174 Rev. C; D2174-041 Rev. C; D2175 Rev. C	<b>Qty:</b>	4 Kits
RF 03.04.30		Page 2 of 2

Step	Location	Procedure	By	Date	Qty																																																
21	KP	<b>Pick: Packing Kit (Note: D2174-041 is not on the BOM, but is in as material from steps 2 &amp; 3)</b> <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>2 ✓</td> <td>D2174-041</td> <td>Web Assembly</td> <td>B16562/B13738/B13732</td> </tr> <tr> <td>1 ✓</td> <td>D2985</td> <td>Decal</td> <td>B14160</td> </tr> <tr> <td>8 ✓</td> <td>A3235-020-935</td> <td>Washer</td> <td></td> </tr> <tr> <td>16 ✓</td> <td>AKS7-1032-130</td> <td>Insert (AKS4-1032-130)</td> <td>M14240</td> </tr> <tr> <td>8 ✓</td> <td>AN3-3A</td> <td>Bolt</td> <td>M14824</td> </tr> <tr> <td>8 ✓</td> <td>AN3H4A ✓</td> <td>Bolt (or AN3H4)</td> <td>M14149</td> </tr> <tr> <td>36 ✓</td> <td>AN525-10R7</td> <td>Screw</td> <td>M14940 / M14603</td> </tr> <tr> <td>8 ✓</td> <td>AN960JD10</td> <td>Washer</td> <td>M13719</td> </tr> <tr> <td>16 ✓</td> <td>AN960JD10L</td> <td>Washer</td> <td>M14312</td> </tr> <tr> <td>16 ✓</td> <td>MS21042L3 ✓</td> <td>Nut (or -3)</td> <td>M14393 / M14478</td> </tr> <tr> <td>8 ✓</td> <td>MS24694S67</td> <td>Screw</td> <td>M14750</td> </tr> </tbody> </table>	Qty	Part Number	Description	Batch	2 ✓	D2174-041	Web Assembly	B16562/B13738/B13732	1 ✓	D2985	Decal	B14160	8 ✓	A3235-020-935	Washer		16 ✓	AKS7-1032-130	Insert (AKS4-1032-130)	M14240	8 ✓	AN3-3A	Bolt	M14824	8 ✓	AN3H4A ✓	Bolt (or AN3H4)	M14149	36 ✓	AN525-10R7	Screw	M14940 / M14603	8 ✓	AN960JD10	Washer	M13719	16 ✓	AN960JD10L	Washer	M14312	16 ✓	MS21042L3 ✓	Nut (or -3)	M14393 / M14478	8 ✓	MS24694S67	Screw	M14750	CRP	01/05/04	4
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22	QC4	Inspect Kit 100% for Completeness on the W/O	W	01/05/04	4																																																
23	ST	Identify and Stock	CRP	01/05/04	4																																																
24	AC	Cost / part 62.02	545	01-08-05	4																																																
25	DC	Close W/O 62.02 Inspect Level 21	CRP	04.05.05	4																																																

Rev	Date	Change	Revised By	Approved
A	03.03.26	New issue	KJ/RF	

**RELEASED**  
03.04.30

Work Order:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

NCR		WORK ORDER NON-CONFORMANCE						
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PAR#:\_\_\_\_\_ Fault Category:\_\_\_\_\_ DQA:\_\_\_\_\_ Date:\_\_\_\_\_

**NOTE:** Date & initial all entries  
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QA: N/C Closed:\_\_\_\_\_ Date:\_\_\_\_\_

# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Apr 12, 2004  
03:42 pm

Work Order No	: 0020694	Department Code:	
Project Name	: K10018	Burden Flags	: NNNNNNN
Project For	: WK418	WO Status	: Open
Work Order Type	: Main	Invoice State	: Not Invoiced
Main WO Number	:	Invoice Date	:
House Part Number	: K10018	Invoice Number	:
Description	: Spacepod Hardware Kit	Invoice Amount	: 0.00
Manufactured	: Yes		
Amount Req'd	: 4	Order Entry No	:
Amount Done	: 0	OE Value	: 0.00
Start Date	: 04-12-04		
Est Finish Date	: 04-30-04	Est Margin	: 0.000%
Act Finish Date	:	Actual Margin	: 0.000%
Drawings Req'd	: No		
Ok for Approval	:		
Approval Rec'd	:	\$0 Posted to Finished Goods	

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Margin	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	: 0.00	0.00
Profits/(Loss)	: 0.00	0.00